

Date: Monday, 3/17/2008 11:56:55 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	STRUT		
Job Number	38027					
Estimate Number	10273					
P.O. Number	:		Part Number	D2565101		
This Issue	3/17/2008	S.O. No. :	Drawing Number	D2565 REV E		
Prsht/Rev.	NC		Project Number	N/A		
First Issue	/ /	Type : SMALL /MED FAB	Drawing Revision	E		
Previous Run	37679		Material	:		
Written By	:		Due Date	3/28/2008	Qty:	20 Um: Each
Checked & Approved By	:					
Comment	Est: P 02.04.16		Added dwg Rev.C1 NG			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	
		Comment: Qty.: 1.7955 f(s)/Unit Total : 35.9100 f(s) 304 RD TUBE .750 X.49W Material: 304/316/318-2B Seamless Tubing, 3/4" O.D. x 0.049" wall per Dwg (M304TR0750W049) Batch M107098 (8) M107245 (12) SB 08/03/17 20	
2.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE Punch as per Dwg D2565 using DT 8313	
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Drill hole open to .316 Ø as per Dwg D2565 (one end only) Deburr and polish	
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	
5.0	POWDER COATING	POWDER COATING	
		Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/03/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 38027

Part Number: D2565101

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(20)

Comment: INSPECT POWDER COAT

X B  
08-03-24

7.0 PACKAGING 1

PACKAGING RESOURCE #1

Identify and Stock

Location: ST270



(20)

Comment: PACKAGING RESOURCE #1

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

AS 08/03/25

Job Completion



AS 08/03/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

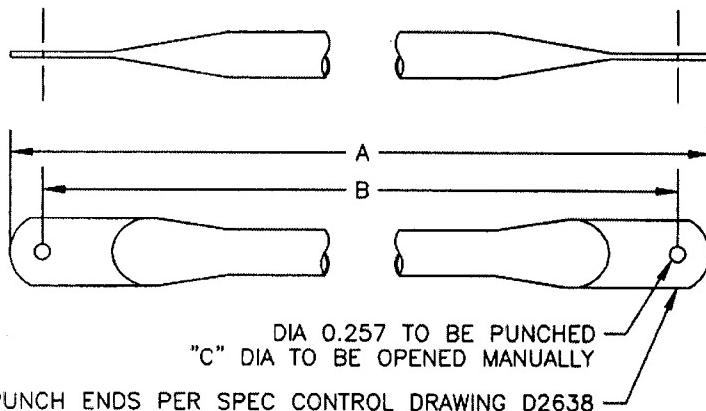
NOTE: Date & initial all entries

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2565	SHEET 1 OF 1
DATE	TITLE		SCALE
04.05.05	STRUT		1:3

**RELEASED**  
 04.05.05

A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	



PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

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 ENGINEERING

 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 NO. 38027
GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
 (REF DART SPEC. M304TR0.750W0.049)  
 ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES